

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019781**Date Inspected:** 23-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Dang Zing Bing.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A5-001

Weld No: 002,008,010

Welders: 056364, 057258, 500363, 052930

WPS-B-T-2211-TC-U4C

Component; Bike Path

PCMK: BK004A -033

Weld No: fit up

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Welder: 040434

WPS-B-T-2213

Heat straightening of PCMK, BK004A6-046 under approved Heat Straightening procedure, HSR1 (B)-9759. The in process temperature was observed as 250°C. The ZPMC QC was identified as Dang Zing Bing. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 12mm.

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Dang Zing Bing.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Tower LIFT 6 (see picture below “tower lift 6”)

PCMK: SSD1-FFSAG-1

Weld No: 5, 6,

Welders: 052075, 040302

WPS-B-T-2132-ESAB

Bay 11

This Caltrans QA Inspector observed at random intervals ZPMC Performing grinding of welds on SA3149, SA3147, SA3138, SA3077. It appears that ZPMC is performing grinding of Visual rejects were ZPMC QC had marked rejectable VT indications.

Bay 12

This Caltrans QA Inspector observed ZPMC performing match drilling in splice plates X40446, OBW13. (see attached picture)

This Caltrans QA Inspector observed at random intervals ZPMC Performing grinding of welds on railings for bike path. It appears that ZPMC is performing grinding of Visual rejects were ZPMC QC had marked rejectable VT indications.

Trial Assembly

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of temporary attachment removal areas. It appears that ZPMC is performing grinding of Visual rejects were ZPMC QC had marked rejectable VT indications. (see attached picture)

Bay 8

This Caltrans QA Inspector observed at random intervals ZPMC Performing grinding of welds on bike path BK004A -064. It appears that ZPMC is performing grinding of Visual rejects were ZPMC QC had marked rejectable VT indications.

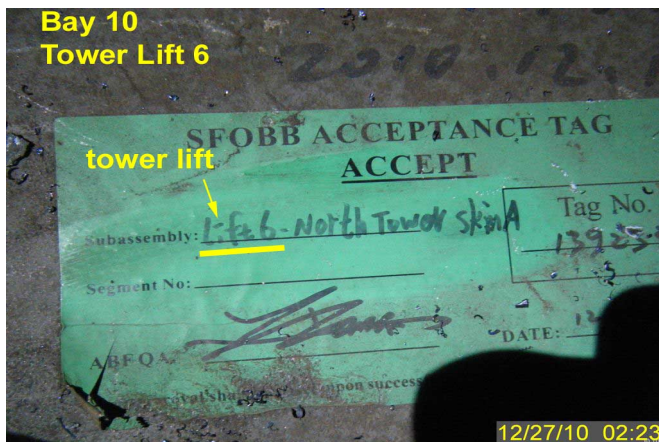
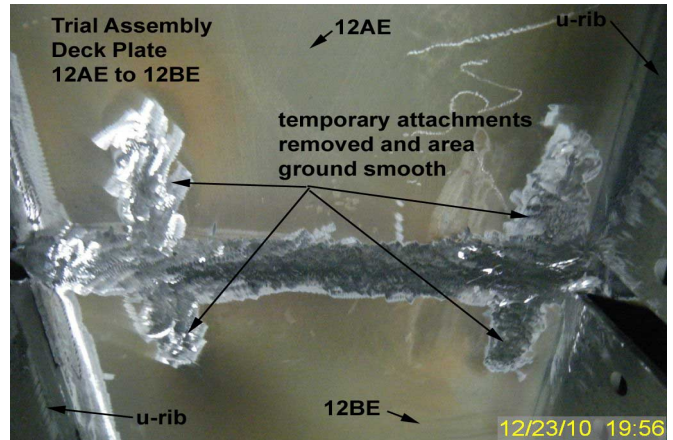
Bay 7

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This Caltrans QA Inspector observed ZPMC performing match drilling in splice plates X8556A, for CB003M.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer